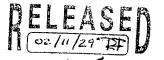
DART AEROSPACE LTD Work Order: Z3

DART AEROSPACE LTD	Work Order:	23233
Description: Ø3.250 Support	Part Number:	D2940-1
Dwg: D2940 Rev. A1	Qty:	V 18
		Page 1 of 1

-3.06.09

Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveller. Blank size makes (2) D2940-1 Dwg not required	A)	05.05.11	. 3
2	PG	Issue P/O: 7008035 Description: D6104-007 Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104			
		Material release note required.	11	050512	12
3	RG	Receive and Inspect for raw material dimensions. Ensure material release note is attached.	ct	05/05/20	10
4	MS	Turn blank for Haas as per Folio FA079		05/08/16	
5	QC1	Inspect all dimensions as per Dwg D2940		05/08/16	
6	MV	Machine as per Folio FA079		05.08.25	
7	MV	Tumble & Deburr] .	05.08.25	1 1
8	QC1	Inspect all dimensions to inspection sheet as per Dwg D2940	خ.ر	05.06.25	
9	QC8	Inspect dimensions for second check	· · · · ·	05/08/25	
10	FP	Powder Coat White (4.3.5.2) per QSI 005 4.3	ノ .	05 08 25	4
11	QC3	Inspect Powder Coat	m	05 08 25	4
12	ST	Identify and stock	DL	oslo8kg	4
13	AC	Cost / part 127.33		05-08-29	4
14	DC	Close W/O / 43.67 Inspect Level 21	30	05/08/29	4

Rev	Date	Change	Revised By	Approved
Α	01.01.08	Preliminary Issue	EC	
В	01.08.15	Removed Heat treating	EC	1
C	02,11.26	Reformat; Added P/O	KJ / TE P	04.



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector					
			i.									

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
	-	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector
		•		•				
						٠,		
			·				•	
							п	
		·						

Part No:	PAR #:	Fault Category: No	CR:	Yes (No) DQA:	Date: <u>05/89/29</u>
NOTE: Date & initial all entries			•	QA: N/C Closed:	Date:

DART AEROSPACE LTD	Work Order: 23233
Description: 0 3.250 Support	Part Number: \(\Dag{940-1}
Inspection Dwg: Λ 2940 - Rev: A 1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		First Artic	le	Proto	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
AA . 250	+ .010	- 250				
AB 500	t-010	. 500		4		
AC -150	+ .010	-155				
AD 3.520	+ .010	3.525				
AE 1.653	+ -020	1.658				
AF 1.503	+ -010	1.502				
AG .050	± .010	.046				
AH \$ 188	+ .002	-190				
AL -150	± .010	146	1			
AJ 2.528	+ -010	2.528				
AK .050	÷.010	-049				
AL 0/0	4.010	-0/0				
021- MA	± -010	-150	1			
KN .400	t -020	-425	1		_	
AO250	±-010	- 250				
AP _/60	± .010	.160				*
AQ .063	+.010	.063	1			
AR 103.64	t 2					
AS 8.257	- · 00 Z	.259				
AT .063	+ -0(0	.063	1			
AU 4.128	+ .010	4.127				
		1.1.3.1				
	,					

Measu	ired by:	J.L	-Audited by:	FE	Prototype A	pproval:	a
	Date:	05.08.23	Date:	65.08.23		Date:	05.08.27
Rev	Date	Change				Revised b	v Approved
A		New Issue				KJ/RF	<u>, ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,</u>

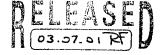
DART AEROSPACE LTD	Work Order:	23233	
Description: Ø3.250 Support	Part Number:	D2940-1	
Inspection Dwg: D2940 Rev. A1		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

		****		Re	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
				Lath	e Section				
Α	3.211	3.216		3.213	3.213	3.214	3.214		
В	4.946	4.966		4-956	4.959	4.956	4.956		,
. C	0.718	0.738		865.0	0.728	0.728	0,128		
D 、	0.090	0.110		0.110	3.574	0.110	0-110		
E	3.564	3.584		3.575	3.574	3.574	3-574		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3 454	3.454	3.454	3 454		
H	0.112	0.132		0.121		0.120	161.0		
	2.170	2.190		2.181	3.182	2.182	9-183		
J	4.451	4.471		4-460	4-460	4.459	4.459		
K	0.413	0.433		0-423		0.422	0.493		
L	0.913	0.933		0.923	0.923	0.924	0.4.89		
M					•	,			
N									
				HAAS	S Section				
AA	0.240	0.260	te-	-250	- 250	250	-250		*
AB	0.490	0.510		-500	- 500	-500	.500		
AC	0.140	0.160	****	-150	.152	0.00	6.151		
AD	3.510	3.530		3.521	3.522	3.527	3.526		•
AE.	1.633	1.673		1.657	1.657	1.657	1.657		
AF	1.493	1.513		1.503	1.500	1.501	1.501		
AG	0.040	0.060		- OA9	-051	0.000	0.058		
AH	0.188	≎0-193	DT8706						
A1	0.140	0.160		0147	148	6-147	0.147		
AJ	2.518	2.538	,	2528	2528	2.528	2.528		
AK	0.040	0.060 4		-049	.048	0.648	0.048		į
AL	0.010	0.020		-010	-010	-010	-010		*.
AM	0.140	0.160		151	-148	P.153	0.149		
AN	0.350	0.450		.425	.425	0.475	0.425		
AO	0.240	0.260		-250	-250	250	- 250		-
AP	0.150	0.170		. 156	-155	0.155	0.155	•	
AQ	0.053	0.073		-063	-06/3	-063	-06/3		
AR	101.64	105.64	DT8698						
AS	0.257	0.262	DT8683						
AT	0.053	0.073		. 063	-063	.063	-063		
AU	4.118	4.138		4-127	4.127	4.127	4.127		
AV:									
AW									
	Acc	ept/Reje	ct						

Measured by: 3.6	S.L Audited by	5 /the
Date: 05/08113/ 05	08.24 Date: 6	5/08/16 05.08.74
		- / - /

Rev	Date	Change	Revised by	/ App#oved
Α	02.12.12	New Issue	KJ/RF	9
-				11



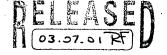
DART AEROSPACE LTD		Work Order:	23233
Description: Ø3.250 Support		Part Number: -	D2940-1
Inspection Dwg: D2940 Rev. A1	3		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

	Recorded Actual Dimensions								
Dim	Min	Max	Go/No Go Gauge	15	26	137	48	Ву	Date
				Lath	e Section ,				
Α	3.211	3.216		3-211	3-216	3.216	3_215		
В	4.946	4.966		4-955	4.956	4.958	4-957		
С	0.718	0.738		865: 9	0.731	0.728	0.727		
D	0.090	0.110		0.110	0.110	0110	0.110		
E	3.564	3.584		3-574	3.575	3.575	3.576		
F	0.022	0.042	_	0.032	0.032	0,032	0.032		
G	3.444	3.464		3-454	3.455	3.454	3.455		
Н	0.112	0.132		0.121	0.121	161.0	0.131		
ı	2.170	2.190		2.181	2.182	2.182	2.183		
J	4.451	4.471		4.460	4.461	4.460	14-460		
·K	0.413	0.433		6.422	0.423	0.424	0.423		
L	0.913	0.933		0.923	0-924	0.934	0.933		
М									
N									
				HAA	S Section				
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193	DT8706						
Al	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170					1		
AQ	0.053	0.073					*		
AR	101.64	105.64	DT8698)		
AS	0.257	0.262	DT8683					ļ	
ΑT	0.053	0.073							
AU.	4.118	4.138							
AV									·
AW									
	Acc	ept/Reje	ct					<u> </u>	

·		<u></u>
Measured by: 1.6	Audited by	
Date: 05/08 / 16/	Date: 05/29/16/	

Rev	Date	Change	Revised by	Approved
Α	02.12.12	New Issue	KJ/RF	9
			•	11



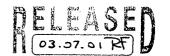
DART AEROSPACE LTD	Work Order:	23233
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940 Rev. A1	·	Page 1 of 1

/Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

			inted on inspe		corded Actu				
Dim	Min	Max	Go/No Go Gauge	1a	210	3	4	Ву	Date
	<u> </u>				e Section				
Α	3.211	3.216		3.214	3.216				
В	4.946	4.966		41-955	4.954				
С	0.718	0.738		865.0	0.797				····
D	0.090	0.110		0.110	0.110				
E	3.564	3.584		3.575	3.574				
F	0.022	0.042		0.033	0.032				
G	3.444	3.464		3.455	93.454				
Н	0.112	0.132		0.121	0.121				
T	2.170	2.190		3.182	3.181				
J	4.451	4.471		4.560	4.560				·
K	0.413	0.433		0.424	0-423				
L	0.913	0.933		0.922	0.924				
М									
N				<u></u>					
				HAA	S Section				•
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193	DT8706						
Al	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160			7.00				
AN	0.350	0.450		1					
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64	DT8698						
AS	0.257	0.262	DT8683					1	
AT	0.053	0.073							
AU	4.118	4.138	· · · · · · · · · · · · · · · · · · ·						
ΑV									
AW									
	Acc	ept/Reje	ct						2

Measured by: 5. G	Audited by Date:	U/A	
Date: 05/08/16	Date.	P 1 /	

Rev	Date	Change	Revised by Ap	proved
Α	02.12.12	New Issue	KJ/RF 🖟	



Job Costing Report

Dart Aerospace Ltd. Hawkesbury

02:16 pm

May 09, 2005

Work Order No : 0023233

Project Name : D2940-1 Project For : WK523 Department Code:

Burden Flags : NNNNNNN WO Status : Open

Work Order Type : Main Main WO Number : Invoice State : Not Invoiced

Invoice Date : House Part Number : D2940-1

Invoice Number : Description : Support

Invoice Amount: 0.00 Manufactured : Yes 1012 u

Order Entry No :

Amount Req'd: 1016 a
Amount Done: 0
Start Date: 05-09-05 OE Value : 0.00

Est Finish Date : 06-05-05

Est Mark Up : 0.000% Actual Mark Up : 0.000% Act Finish Date : Drawings Reqd : No Ok for Approval :

Approval Rec'd : \$0 Posted to Finished Goods

		Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
		========	========	======		
Burden	:	0.00	0.00	0.00		
		========	========	======		
Total Cost	:	0.00	0.00	0.00		
Mark up	:	0.000	0.000			
Selling Cost	:	0.00	0.00			•

Estimated Actual Labour Hrs/Amount Done : 0.00 0.00 Profits/(Loss) : 0.00 0.00



GLORIA MATERIAL TECHNOLOGY CORP.

台南縣新營市新中路35號1樓

1FL ,NO.35, HSIN CHUNG RD , HSIN YING,

TAINAN, TAIWAN, ROC

INSPECTION

CERTIFICATE

TEL:

(06)6520000

FAX:

(06) 6520088

Messrs:

PROGRESSIVE ALLOY STEEL UNLIMITED L.L.C.

Order No: 2004003262

Grade: 17-4PH

P.O.NO.: 3370

FILE NO:

2004004782-A

Size: 4-1/2" Date:

11/30/2004

Date Cust W/Q # **Qnty**

From TMX

Chalemer Part #

MEAT-Lot No: \$2301-40

Weight: 1026.0KG

P'cs:

Condition: HF-Solution Annealed-Peeled

Chemica	al Compos	sition (wt%)								
	С.	Si	Mn	P	S	Ni	Çr	Мо	Cu	Nb+Ta	
Min.	-				0.015	3.00	15.00		3.00	0.15	
Max.	0.07	1.00	1.00	0.040	0.030	5.00	17.50	0.50	5.00	- 1/4	~·~ 4;. 1 ;
Result	0.03	0.36	0.64	0.021	0.023	4.48	15.79	0.13	5.00 3.25	*- [[]** =	

Mechanical Properties Spec

	Hardness (1/2R)	Grain Size	δ -Ferrite	H900-Hardness(Avg)
Spec.Min.				40HRC
Spec.Max.	363HB		5%	47HRC
Result	333HB	7.5	0.64%	45.1HRC

Tensile Test

Unit Min.	Elongation(A) % 10	Tensile Strength(Rm) KSI 190	Yield Strength(Rp) KSI 170	Reduction of % 1
Max. Result	20	210	184	53

Non-Metallic Inclusions : (AMS 2303C)

Severity Frequency

0.35 0.4

Result 0

Specification:

- 1.ASTM A484M-03a, A564M-04, A370-03a. 2.ASME SA484 (1998), SA564 (1998).
- 3.AMS 5643Q, 2303C(Magnetic Particle Test).
- 4.EN 10204/3.1.B.
- 5.UNS S17400.
- 6.SAE AMS-H-6875.

Remark:



Hsin-Jung Huang
OA SECTION
shing say

These less reports are last material shipped

Special Instructions

Our quality and environment management system have been certified by ISO9001 QMS and 14001EMS
We hereby certify that the material described herein has been manufactured and tested with satisfactory result in accordance with the requirement of the above material specification We hereby inspection Certificate comply with EN10204 3.1.B.



GLORIA MATERIAL TECHNOLOGY CORP.

台南縣新營市新中路35號1樓

1FL., NO 35, HSIN CHUNG RD , HSIN YING,

TAINAN, TAIWAN, ROC

INSPECTION

CERTIFICATE

(06) 6520000 TEL:

(06) 6520088

Messrs:

PROGRESSIVE ALLOY STEEL UNLIMITED L.L.C.

FILE NO:

2004004782-A

4-1/2" Size:

11/30/2004

Grade: 17-4PH

P.O.NO.: 3370

Order No: 2004003262

Weight: 1026.0KG

P'cs:

HEAT-Lot No: S2301-40

Condition: HF-Solution Annealed-Peeled

1.MANUFACTURING PROCESS: EAF+LHF+VOD, FORGED OR HOT ROLLED.
2.SOLUTION TREATMENT: 1900F FOR 30 MIN/INCH PLUS ONE ADDITIONAL HOUR (MINIMUM ONE HOUR), RAPIDLY COOLED TO BELOW

3. MATERIAL IS FREE FROM KNOWN CONTACT WITH MERCURY AND RAIUM.

4 MATERIAL IS FREE FROM WELDS OR WELD REPAIRS.

5. ULTRASONIC TEST: OK.

6. MACRO/MICRO OK.

7 MECHANICAL PROPERTIES TESTED AS PER H900 CONDITION.

8. REDUCTION RATION 4:1 MIN

9. FURNACES CALIBRATED TO MIL-H-6875.









<u>Hsin-Jung Kuang</u>

Our quality and environment management system have been certified by ISO9001 QMS and 14001EMS.

We hereby certify that the material described herein has been manufactured and tested with satisfactory result in accordance the above material specification We hereby inspection Certificate comply with EN10204 3.1 B.

• •